

Work Order ID 63571

Thursday, November 04, 2010 1:13:44 PM

Page 1

Item ID: D3535-23

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 11/4/2010 Start Qty: 12.00

Required Date: 11/12/2010 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date: 10-11-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B-

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 . 040

1810-11-15

13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1810-11-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Dishuke

AB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 11/12/2010 Req'd Qty: 12.00

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Cust Item ID:

Customer:

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

I-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
joggle as per Dwg D3535 using Jig DT8158
3-Identify as D3535-23

0.00

0.00

13

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

+13

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

Memo

START TIME:

FINISH TIME:

0.00

0.00

OVEN TEMPERATURE:

M112588

2:25

2:55

13 BR 10-11-17

W/O:		WORK ORDER CHANGES					
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Page 3

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

=> ML 10/11/18

13

Ø

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *FP-21*

0.00

Packaging

Memo

0.00

Packaging

13 BK 10-11-18

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/18
MLF
10-11-18

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 1:13:48 PM

Page 1

Work Order ID: 63571

Parent Item: D3535-23

Parent Item Name: Wearshoe



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

165.0000

1.3615

17.19789

17.7



304/316 .040 Sheet



18-10-11-05

Location

Loc Qty

Loc Code

MAT

161

115762

10.2

115953

150.8

MAT20

4

113062

1.398

115440

2.602

115953

13

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>63571</u>
Description: Wearshoe		Part Number: D3535-23
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	*		V 1802	
2.000	+/-0.010	2.000	*		V	
4.750	+/-0.010	4.756	u		T 1801	
9.500	+/-0.010	9.506	>		T	
14.250	+/-0.010	14.250	u		T	
17.750	+/-0.010	17.756	>		T	
23.140	+/-0.010	23.140	x		T	
28.530	+/-0.010	28.530	4		T	
33.920	+/-0.010	33.926	4		T	
39.310	+/-0.010	39.310	>		T	
44.700	+/-0.010	44.706	x		T	
48.200	+/-0.010	48.206	x		T	
52.850	+/-0.010	52.856	x		T	
Ø0.188	+0.005/-0.001	.191	*		V	
48.00	+/-0.030	48.00	g		T	
39.00	+/-0.030	39.00	x		T	
32.00	+/-0.030	32.00	x		T	
24.00	+/-0.030	24.00	x		T	
16.00	+/-0.030	16.00	x		T	
8.00	+/-0.030	8.00	x		T	
6.00	+/-0.030	6.00	x		T	
0.300	+/-0.010	.303	x		V	
0.300	+/-0.010	.302	x		V	
0.038	+/-0.010	.036	x		V	

Measured by: <u>IB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>10-11-15</u>	Date: <u>10/11/16</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	<u>[Signature]</u>

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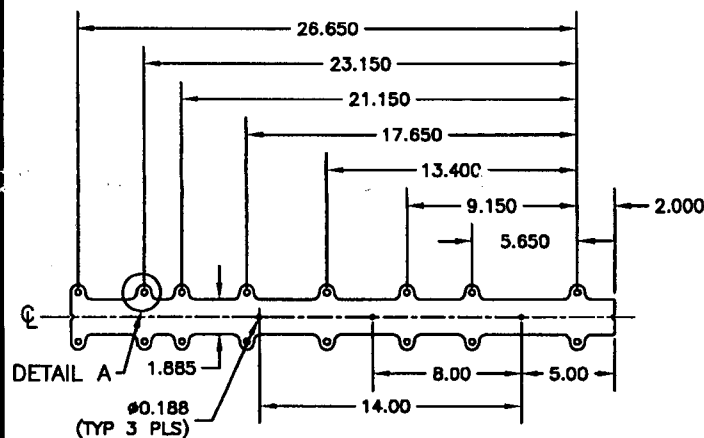
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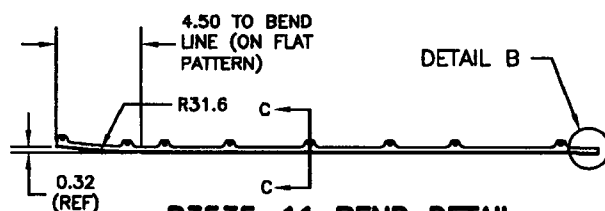
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07.04.17

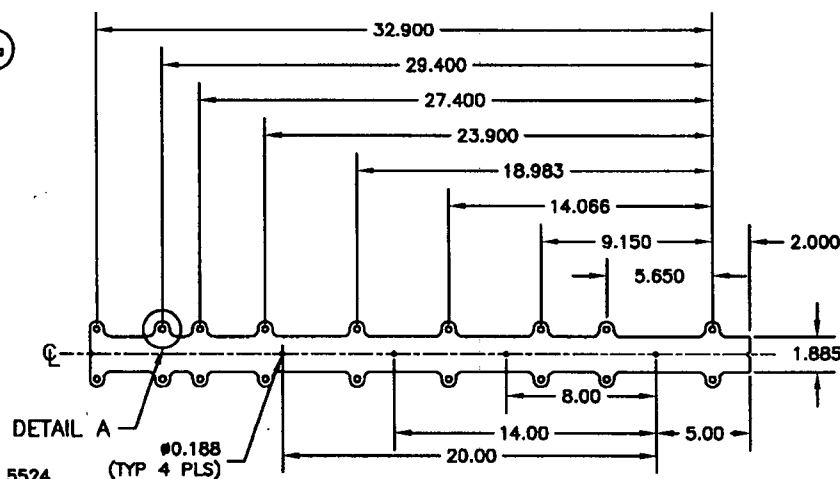
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43571
B/10-11-04



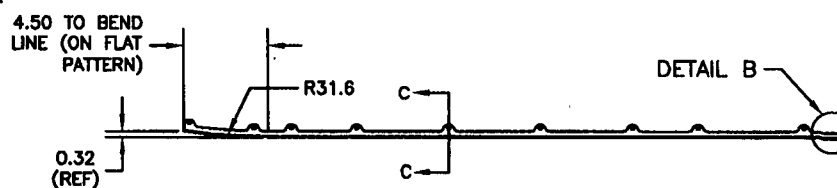
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	TITLE	DATE
CB	PH	WEARSHOE	07.04.17
CHECKED	APPROVED	DRAWING NO.	SCALE
		D3535	1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. B
SHEET 1 OF 7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

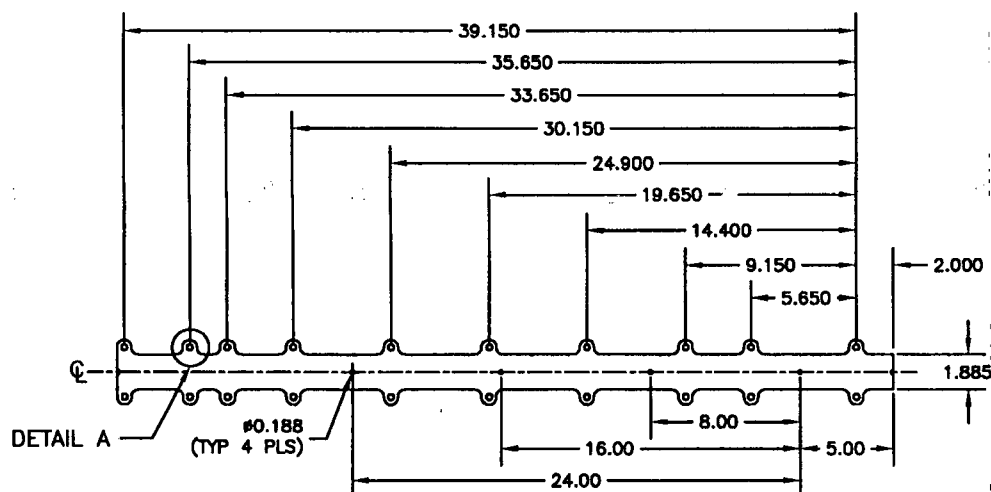
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DART

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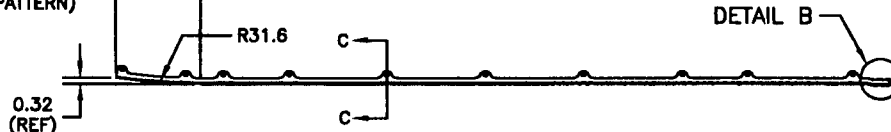
07.04.24

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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 2 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	



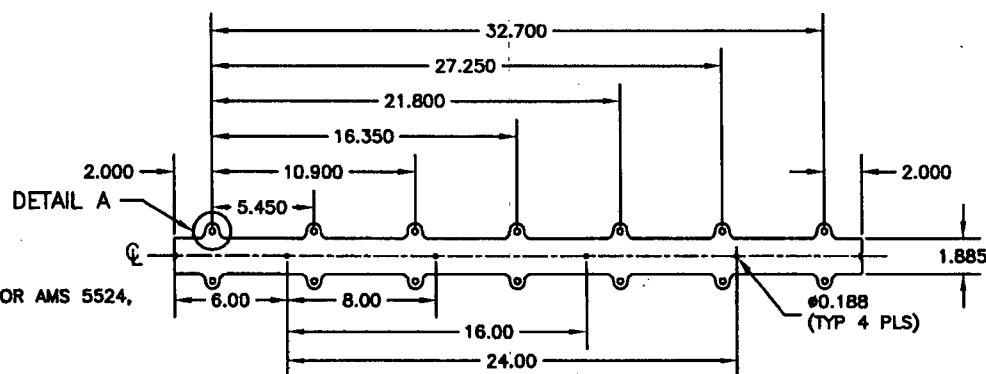
4.50 TO BEND
LINE (ON FLAT
PATTERN)

D3535-15F FLAT PATTERN

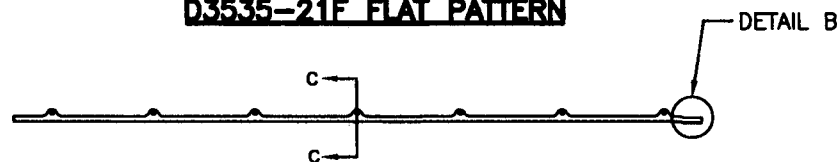


D3535-15 BEND DETAIL

w/o 63571



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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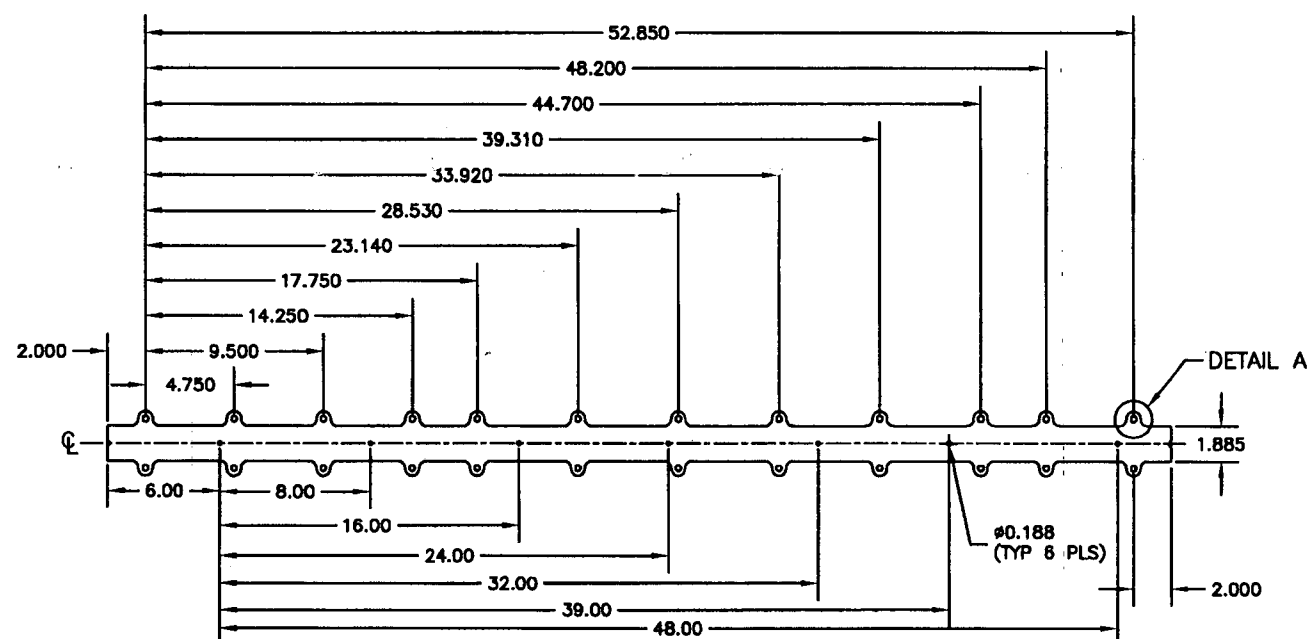
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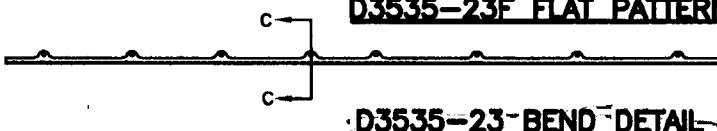
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07.04.24

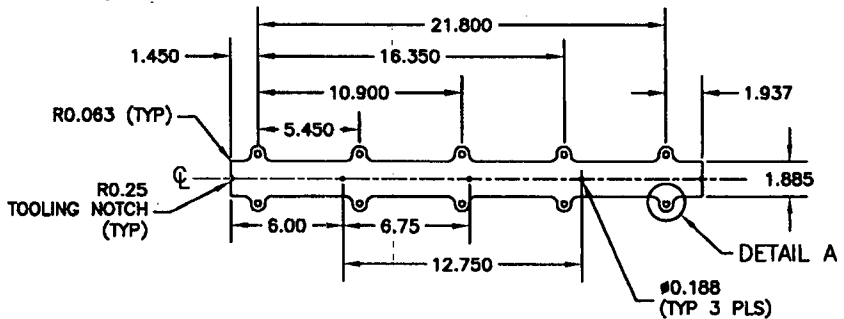
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE
		1:10



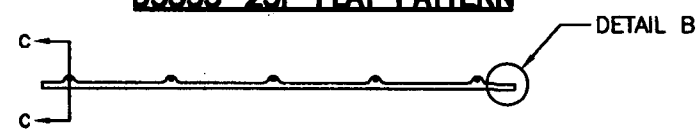
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

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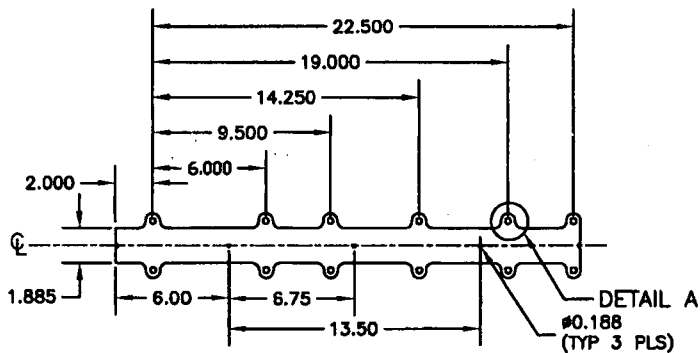
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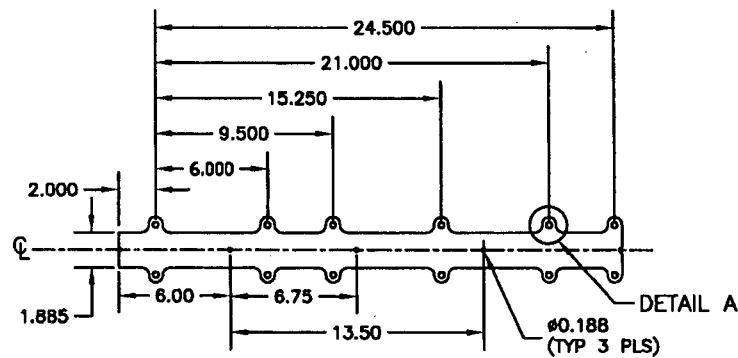
07.04.24



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

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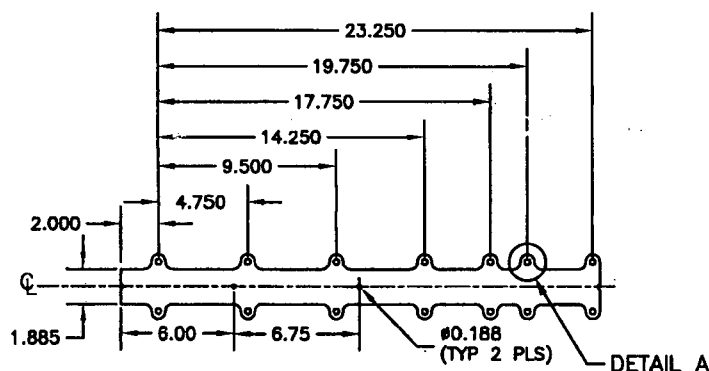
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DART

RELEASED

07.04.17

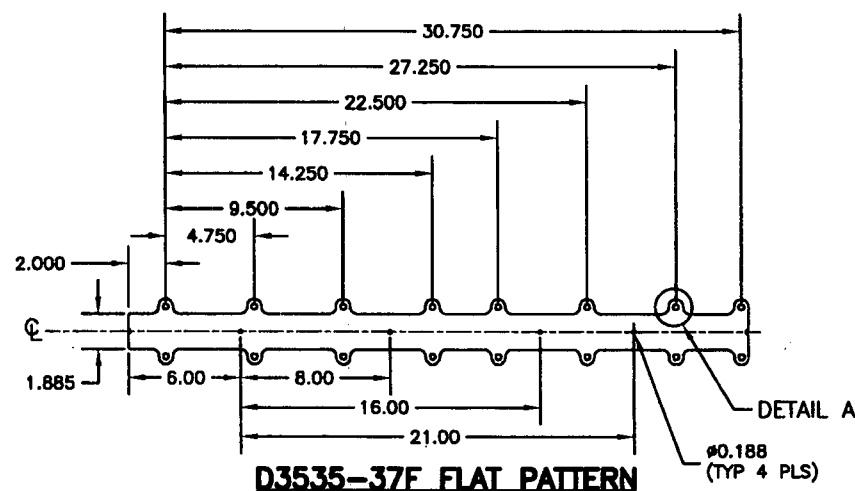
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 5 OF 7
		D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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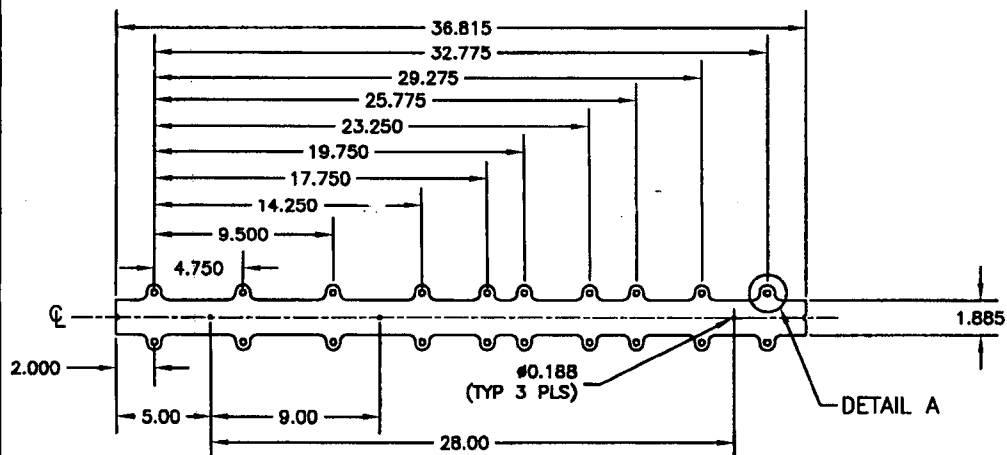
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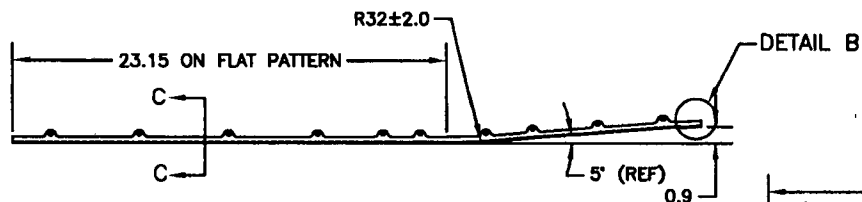
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07 04 17

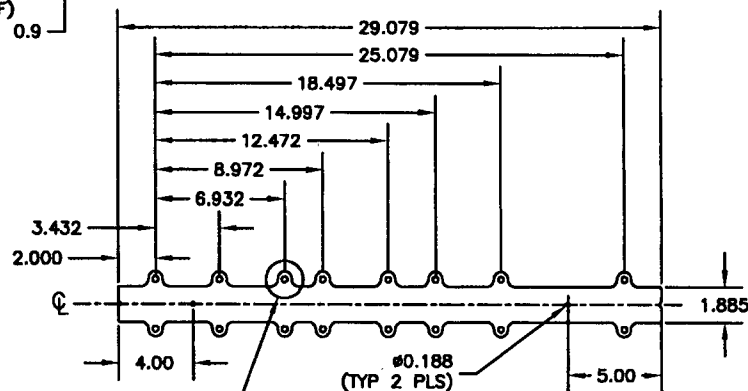
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 6 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10



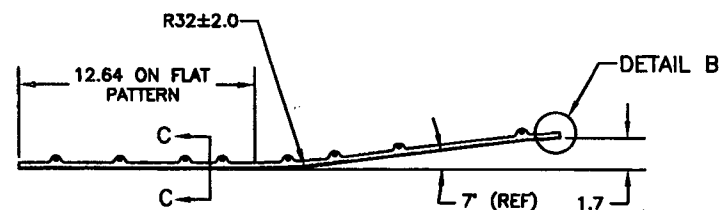
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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- 3) PART IS SYMMETRICAL ABOUT C
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

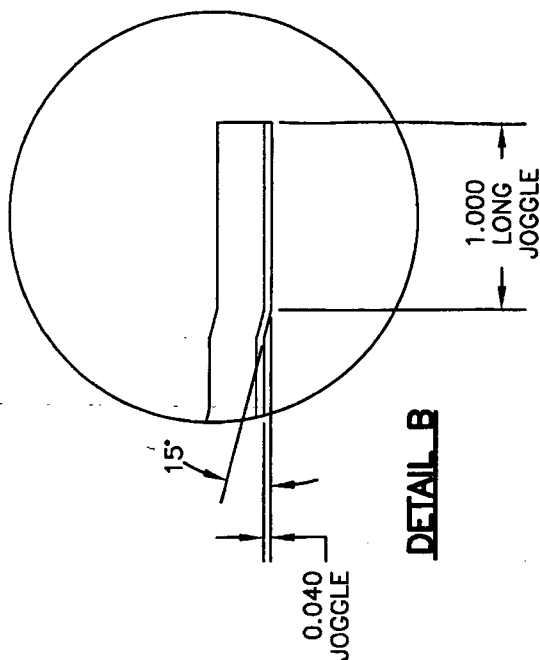
NOTE: Date & initial all entries



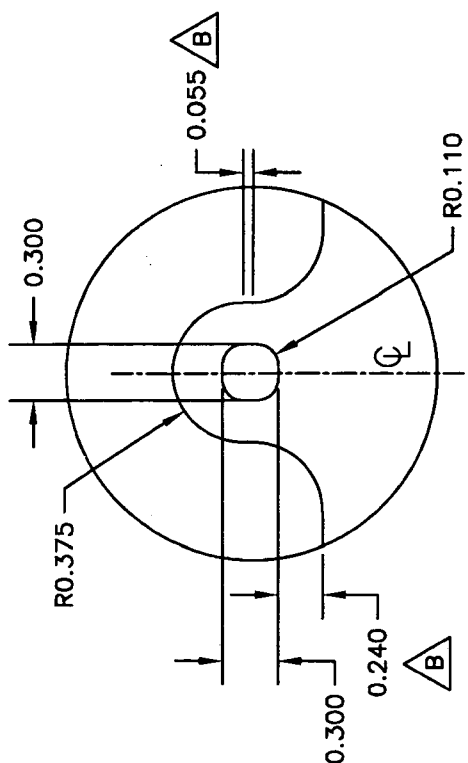
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

RELEASED

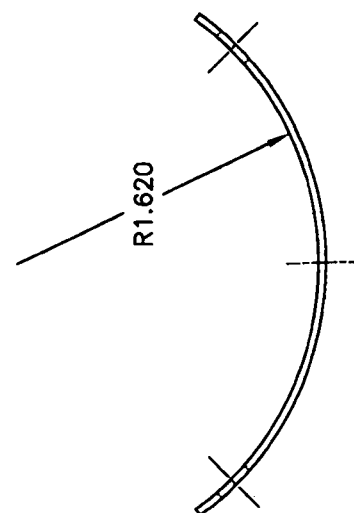
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries